

shp Oct. 25

Work Order ID 91374

\*91374\*

Item ID: D4410-9 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Trigger  
Start Date: 10/05/12 Start Qty: 12.00 \*12\* Cust Item ID:  
Required Date: 10/12/12 Req'd Qty: 12.00 \*12\* Customer:  
Reference:

Approvals: Process Plan: MLS Date: 12-10-05 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4410	REV B

100 105.00

0.00

\*100\*

Waterjet  
FLOW CNC Waterjet

Memo  
CUT AS PER DWG  
DWG REV: 8  
PROG REV: 3

0.00

6061 .250

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC  
Quality Control

Memo

0.00

100.

MANUAL MILL  
FACE TO SIZE

12-10-11

12-10-11

12-10-11

PTO

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: HA Date: 12/10/17QA Closed: CK Date:

Work Order: <u>91374</u> Part No. <u>D4410-9</u> NCR No. <u>12-1973</u>				<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b> <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input checked="" type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																								
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>																								
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data <input checked="" type="checkbox"/>	12/10/17	100	10	→ 6 parts are .243 → 4 parts are .244  Tolerance is $250^{+0.000}_{-0.005}$ and is marked as reference DWG NOT CLEAR: DIM IS REF OR TOL ABST?	DAS 22 12.10.17	ACCEPTABLE DEVIATION THIS W/O. DWG NOT THAT CLEAR. IS IT REF OR DIM THE TOL NEED?	12-10-17	D.A 12/10/17	DAS 16 12/10/17																		
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
Setup <input type="checkbox"/>																											
Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

**FAULT CATEGORY**

<b>Landing Gear</b> <input checked="" type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
--	---	---

<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input checked="" type="checkbox"/> Other
--	---	---



(10) 12

**Work Order ID 91374****\*91374\***

Page 4

October-05-12 11:28:26 AM

Item ID: D4410-9

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Trigger

Stop

**\*NS2\***

Start Date: 10/05/12 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 10/12/12 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*220\***

Packaging

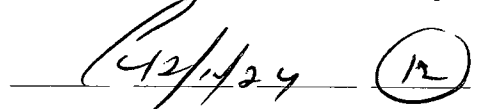
Packaging

Memo

107

0.00

Packaging



230

QC21- Final Inspection - Work Order Release

0.00

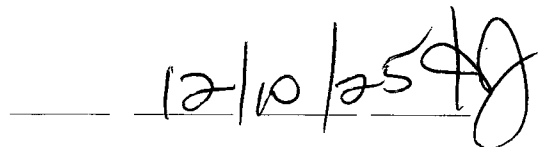
**\*230\***

QC

Memo

0.00

Quality Control



# Picklist Print

October-05-12 11:28:25 AM

Page 1

Work Order ID: 91374

Parent Item: D4410-9

Parent Item Name: Trigger

Start Date: 10/05/12

Required Date: 10/12/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No				sf	29.9000		0.0252636	1	10/12-10-11	
<del>M6061T6 SHEET .250</del>													

Location	Loc Qty	Loc Code
MAT021	29.9	
116808	16.4	
121194	13.5	

60

M6061T6B.250x2.50"

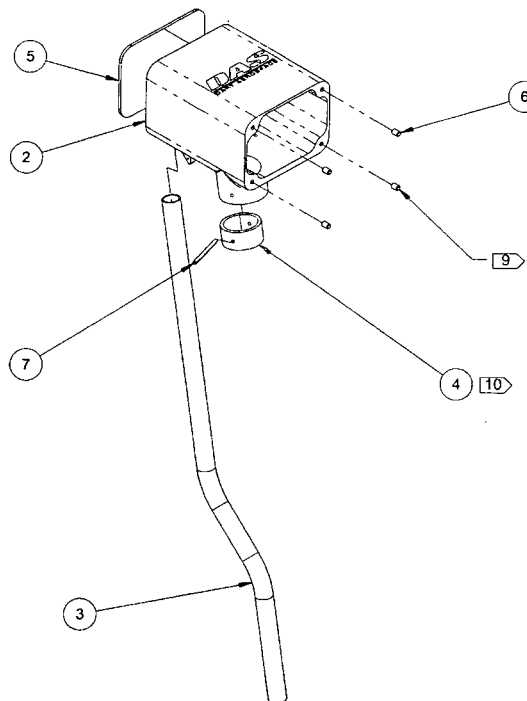
10/12-10-11.

M106652

116808

15

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4410-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-11	205 SHIM
5	1	D4410-15	REAR COVER
6	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	1	MS171539	PIN



# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING
- 10) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

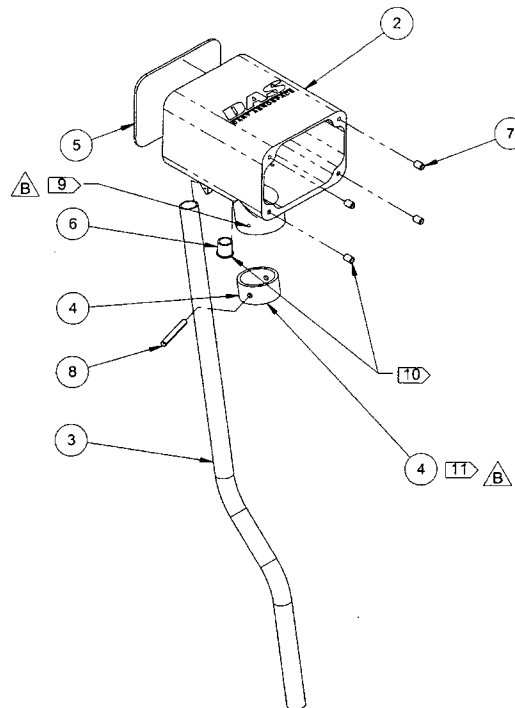
## D4410-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 91374 MLCJ  
12-10-05

## D4410-041 WELDING DETAIL (-041 SHOWN, -043-045 SIMILAR)

B	ADD C'BORE, ZN A4-2. ENLARGE HOLES, ZN C5-3 & B8-3. UPDATE LOGO, ADD -045/-11/-13/-15. ROTATE HOLE, ZN C3-2 INCREASE 7 DIAMETER, ZN C1-6. REMOVE -9 FROM -041 ASSEMBLY, ZN C5-1.	DC	12.07.30
A	NEW ISSUE	DC	11.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN	BC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		DRAWING NO. REV.
APPROVED	BC		D4410 SHEET 1 OF
DE APPR.	BC		TITLE SCAL
DATE	12.07.30		CO-PILOT COLLECTIVE HEAD NT
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4410-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	1	D4413-1	DOME PLUG
7	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
8	1	MS171599	PIN



# NOTES:

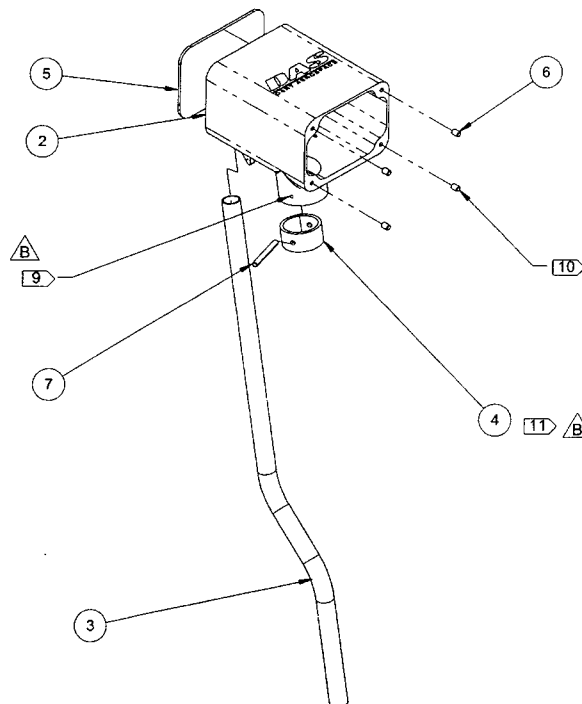
- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) REAM TO Ø0.177 (DRILL #16)
- 10) INSTALL AFTER ANODIZING
- 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

## D4410-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	ST	D4410	SHEET 2 OF 12
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	CO-PILOT COLLECTIVE HEAD	NTS
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ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4410-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	1	MS171599	PIN

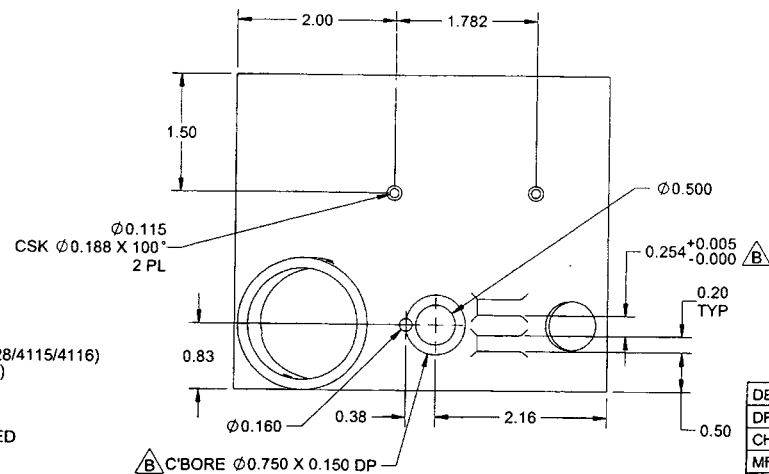
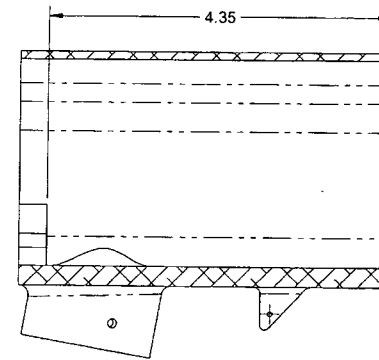
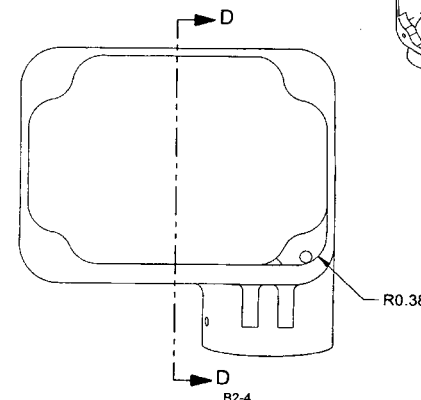
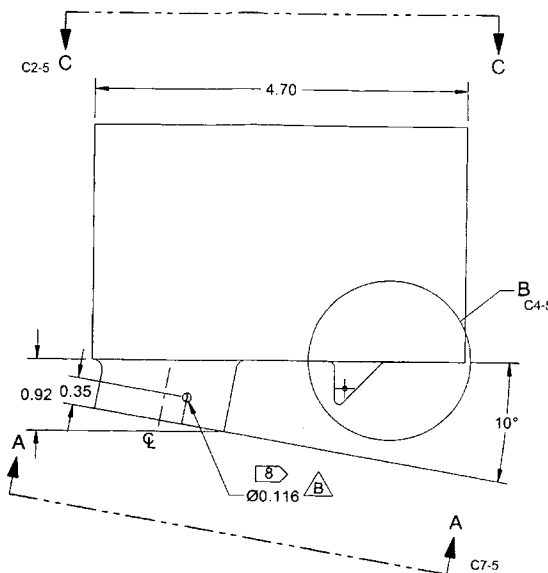
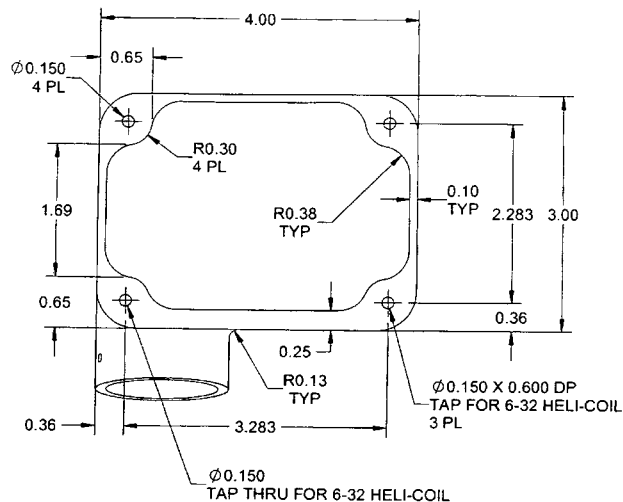


# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) REAM TO Ø0.177 (DRILL #16)
- 10) INSTALL AFTER ANODIZING
- 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

**D4410-045 CO-PILOT COLLECTIVE HEAD ASSEMBLY  
(EAGLE SINGLE)**

DESIGN	BC	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	2/1	D4410	SHEET 3 OF 12
APPROVED	1/19	TITLE	SCALE
DE APPR.	1/19	CO-PILOT COLLECTIVE HEAD	NTS
DATE	12.07.30	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

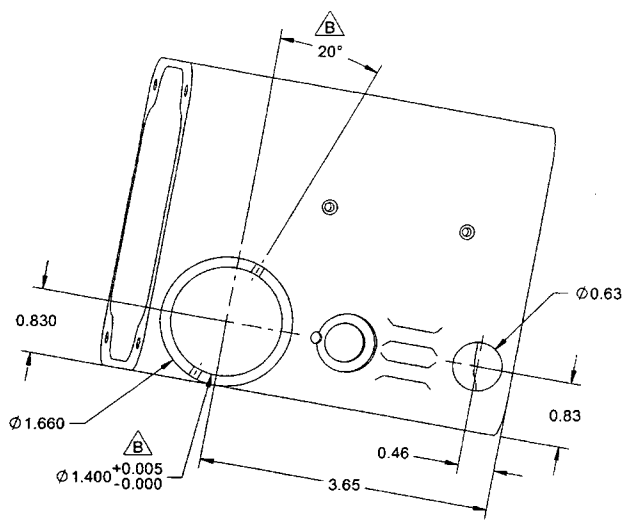


- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF. DART SPEC. M6061T6B4.000X3.000
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 1.24 lbs
  - 8) HOLE IS ROTATED 20° COUNTER-CLOCKWISE WHEN VIEWED FROM ABOVE

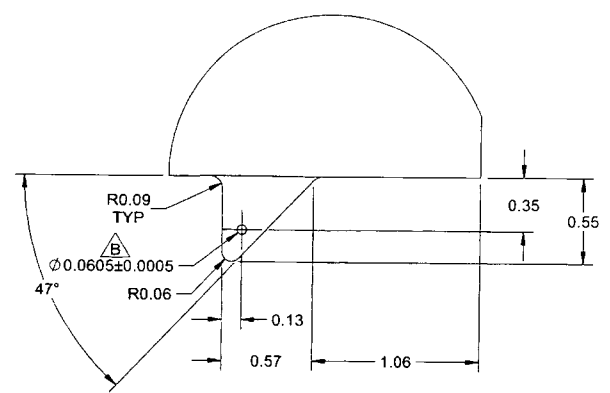
**D4410-1 CO-PILOT COLLECTIVE HEAD**

DESIGN	BC	DART AEROSPACE USA, INC.	REV. B
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO. D4410	SHEET 4 OF 12
MFG. APPR.	BC	TITLE	SCALE
APPROVED	BC	CO-PILOT COLLECTIVE HEAD	NTS
DE APPR.	BC	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	
DATE	12.07.30	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

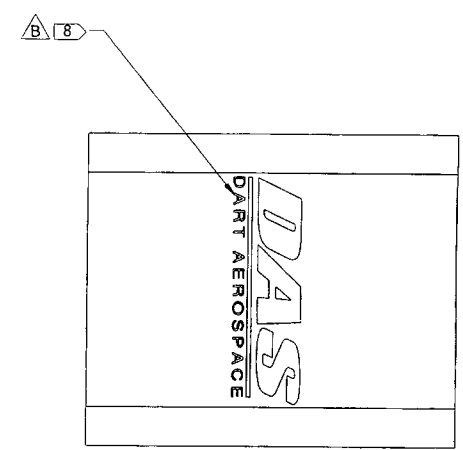
91374



**VIEW A-A**  
C5-4



**DETAIL B**  
C4-4



**VIEW C-C**  
D4-4

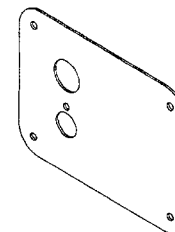
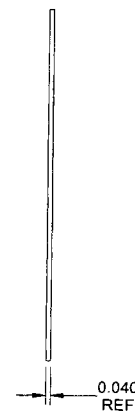
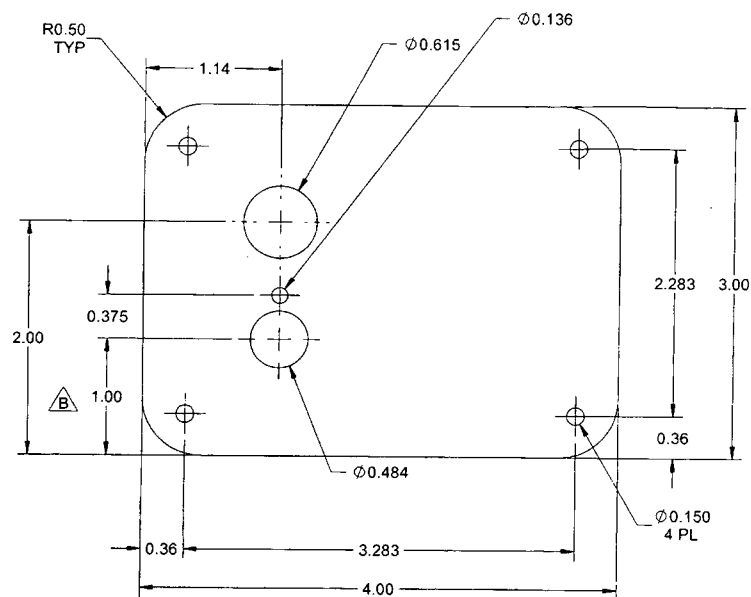
**D4410-1 CO-PILOT COLLECTIVE HEAD  
DETAIL VIEWS**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A
  - 8) ENGRAVE "DAS" LOGO AS SHOWN 0.003 - 0.005 DP.

RELEASED  
2012-09-28

DESIGN	BC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4410	SHEET 5 OF 12
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CO-PILOT COLLECTIVE HEAD	NTS
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91324



**D4410-3 FACE PLATE**

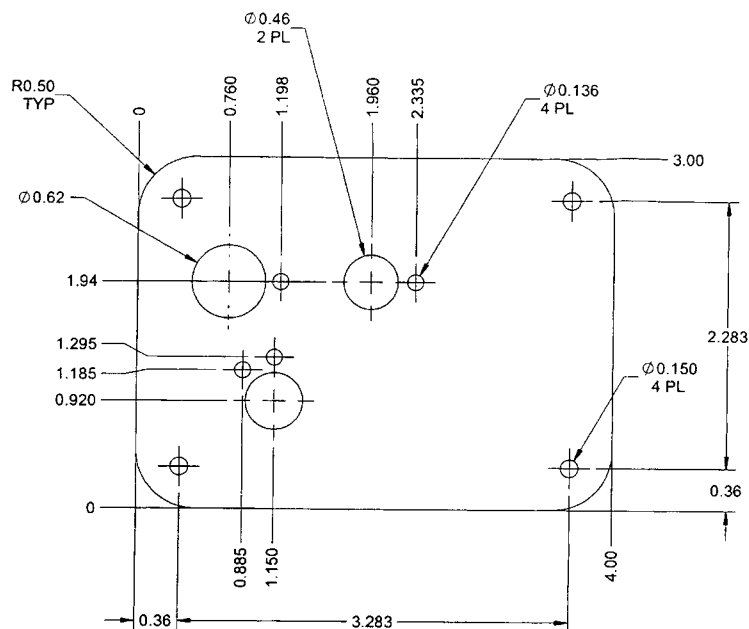
**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK  
QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF. DART SPEC. M6061T6S 040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

2012-09-28

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	SP	DRAWING NO.	REV. B
MFG. APPR.	SP	D4410	SHEET 6 OF 12
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	CO-PILOT COLLECTIVE HEAD	NTS
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91374



**D4410-5 FACE PLATE**

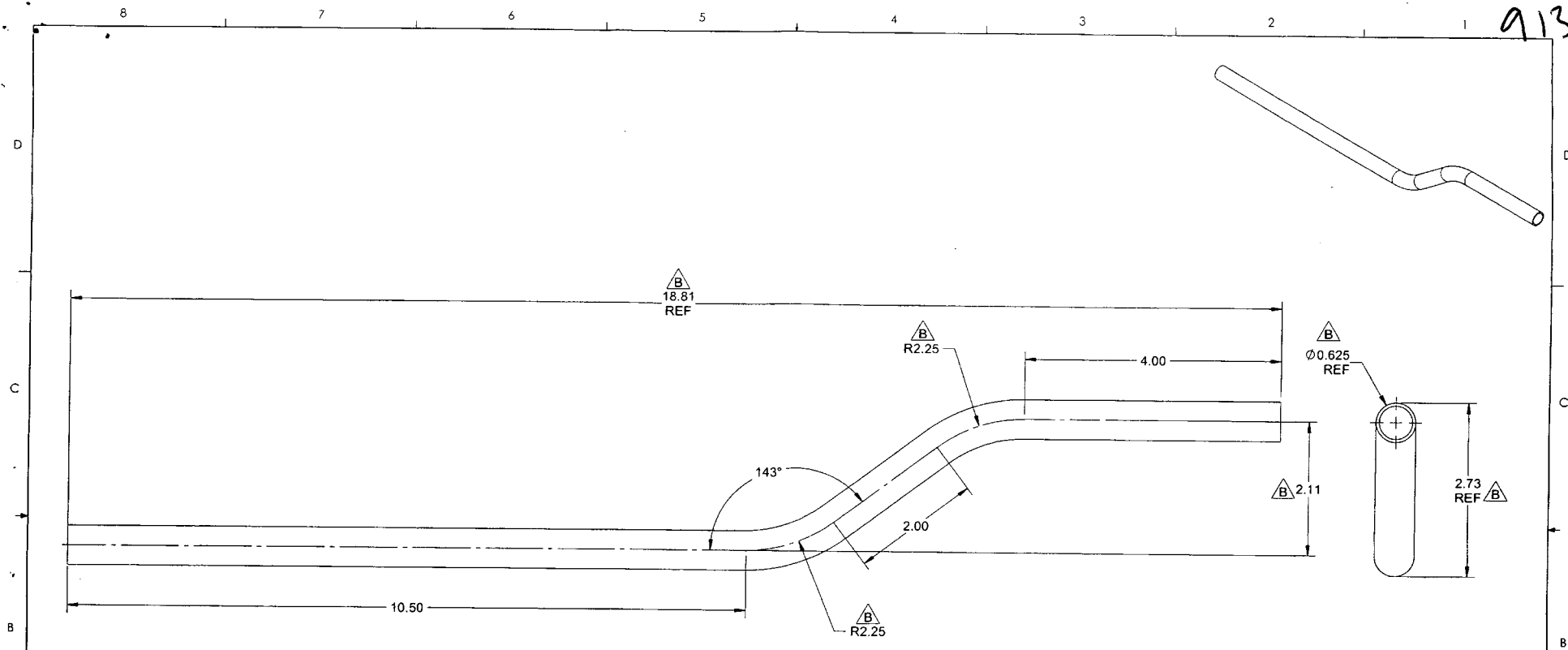
**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK  
 QQ-A-250/11 OR AMS-QQ-A-250/11  
 OR AMS 4025 OR AMS 4027  
 OR ASTM B209  
 REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

**RELEASED**  
 2012-09-28

DESIGN	DC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DC	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	<b>D4410</b>	SHEET 7 OF 12
APPROVED	140	TITLE	SCALE
DE APPR.	140	<b>CO-PILOT COLLECTIVE HEAD</b>	NTS
DATE	12.07.30	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

91374



**D4410-7 CONDUIT**

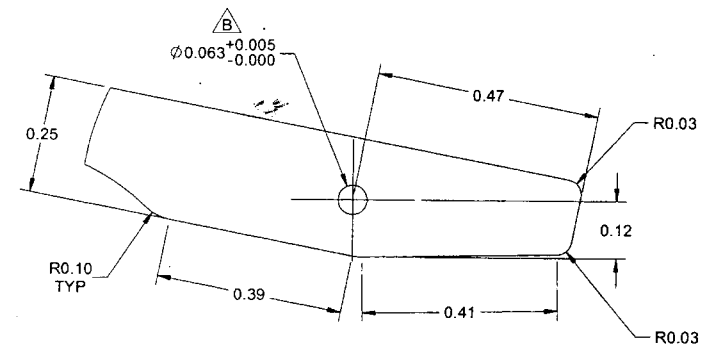
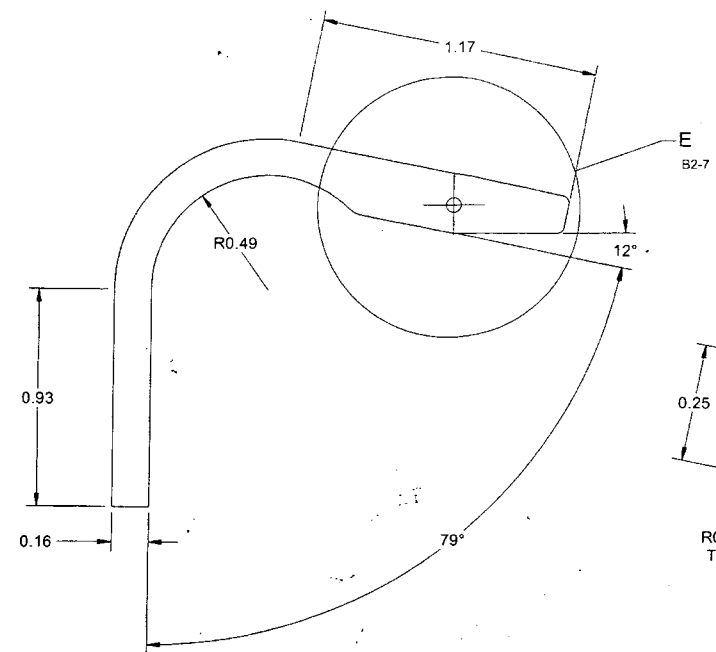
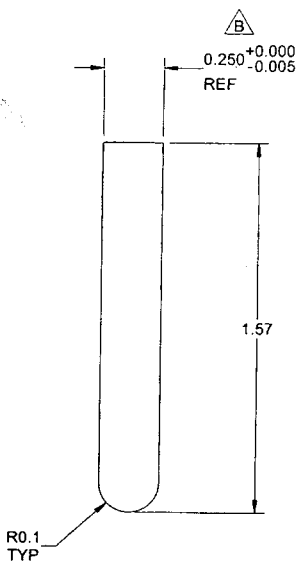
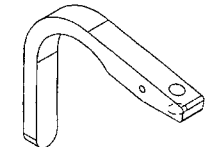
RELEASED  
2012-09-28  
JND

**NOTES:**

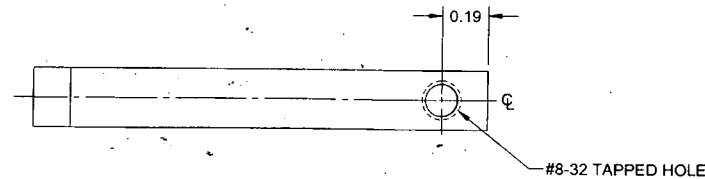
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING PER  
WW-T-700/6 OR AMS 4080 OR AMS 4082  
OR QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T60.625W.050  $\triangle B$
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.17 lbs

DESIGN	DC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DC	KENT, WA	
CHECKED	BE	DRAWING NO.	REV. B
MFG. APPR.	SH	D4410	SHEET 8 OF 12
APPROVED	14	TITLE	SCALE
DE APPR.	SH	CO-PILOT COLLECTIVE HEAD	NTS
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DETAIL  
D4-7



D4410-9 TRIGGER

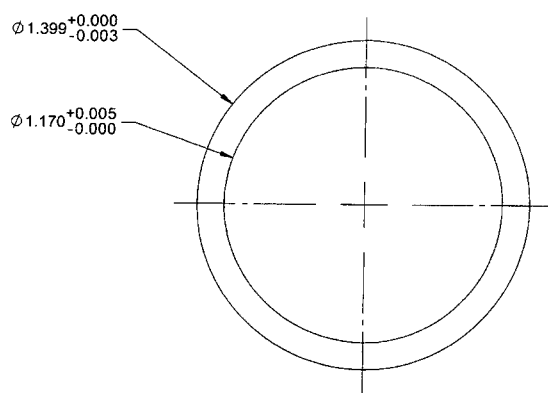
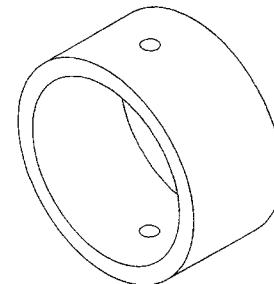
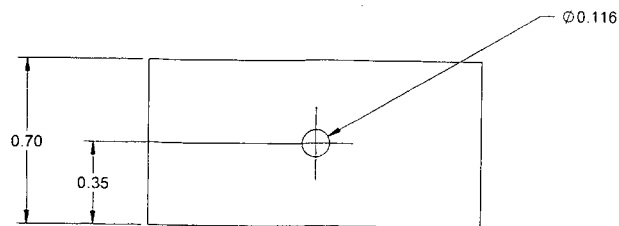
RELEASED  
2012-09-23

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.250 THK  
QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF. DART SPEC. M6061T6S.250
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005-TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	BC	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4410	SHEET 9 OF 12
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CO-PILOT COLLECTIVE HEAD	NTS
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**D4410-11 205 SHIM**

**RELEASED**  
2012-09-23  
AND

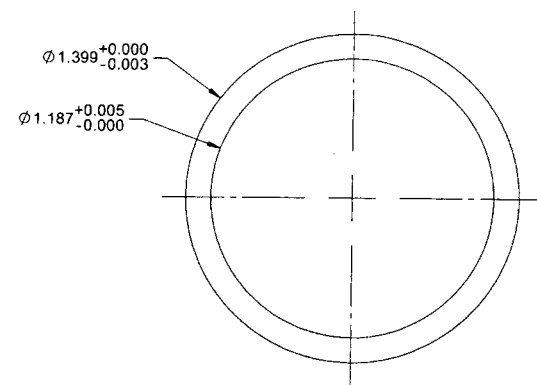
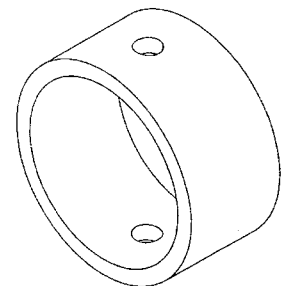
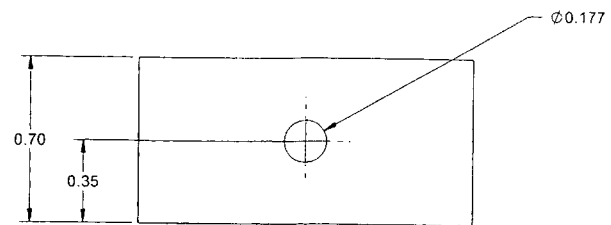
**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR  
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN	DC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DC	KENT, WA	
CHECKED	DC	DRAWING NO. <b>D4410</b>	REV. B
MFG. APPR.	DC	SHEET 10 OF 12	
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	<b>CO-PILOT COLLECTIVE HEAD</b>	NTS
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**D4410-13 212 SHIM**

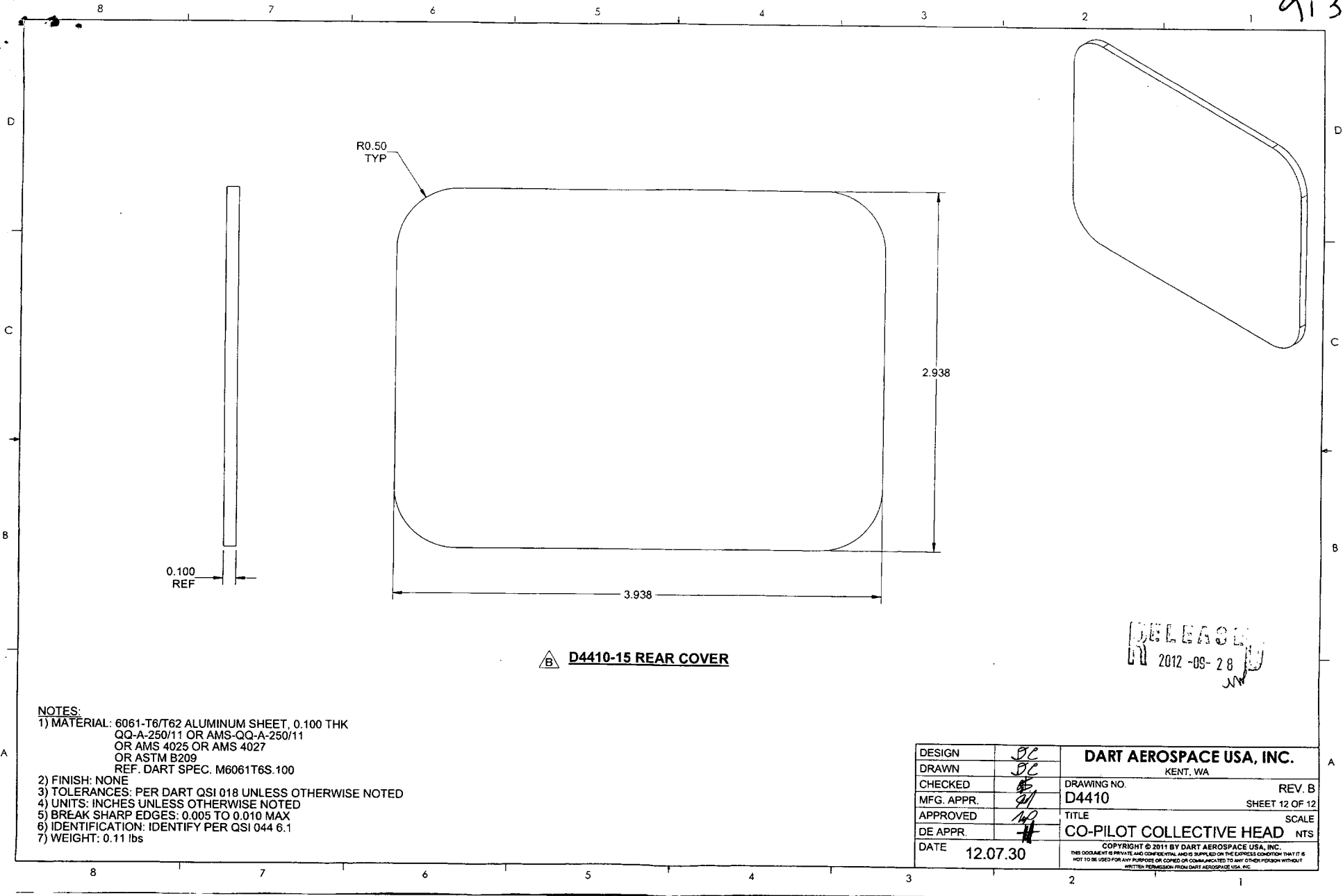
**RELEASED**  
2012-09-28  
WMP

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR  
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN	DL	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DL	KENT, WA	
CHECKED	DL	DRAWING NO. <b>D4410</b>	REV. B
MFG. APPR.	DL	SHEET 11 OF 12	
APPROVED	DL	TITLE	SCALE
DE APPR.	DL	<b>CO-PILOT COLLECTIVE HEAD</b>	NTS
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**D4410-15 REAR COVER**

RELEASE  
2012-09-28

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.100 THK  
QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF. DART SPEC. M6061T6S.100
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

DESIGN	DC	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	DC		
CHECKED	SE	DRAWING NO.	REV. B
MFG. APPR.	21	<b>D4410</b>	SHEET 12 OF 12
APPROVED	140	TITLE	SCALE
DE APPR.	H	<b>CO-PILOT COLLECTIVE HEAD</b>	NTS
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	91374
<b>Description:</b> TRIGGER		<b>Part Number:</b>	D4410-9
<b>Inspection Dwg:</b> D4410-9 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.16	$\frac{+}{-} .031$	.162	L		V BSR	
.93	$\frac{+}{-} .030$	.930	2		V	
1.17	$\frac{+}{-} .030$	1.17	2		V	
<del>.47</del>	<del><math>\frac{+}{-} .030</math></del>					
<del>.17</del>	<del><math>\frac{+}{-} .030</math></del>					
.41	$\frac{+}{-} .030$	.41	1		V	
.39	$\frac{+}{-} .030$	.39	1		V	
.25	$\frac{+}{-} .030$	.260	2		V	
.256	$\frac{+}{-} .010$	.257	2		V	
.19	$\pm .030$	.184	—		RA26	Very
.47	$\pm .030$	.474	1		"	
.12	$\pm .030$	.124	—		"	
Ø.063	$\pm .004$ $\pm .001$	.064	—		"	
R.1	$\pm .030$	R.1	—		"	
.250	$\pm .0003$	.245	—		RA26	Very

<b>Measured by:</b> B <i>[Signature]</i>	<b>Audited by:</b> Smp	<b>Preliminary Approval:</b>
<b>Date:</b> 12-10-11 12-10-15	<b>Date:</b> 12-10-18	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*[Signature]* 10.04.15



A.T.G. Industries Inc.  
731, rue Industrielle Rd.  
PLATING DEPARTMENT  
Rockland, On K4K 1T2  
Canada  
Ph: (613) 446-4544  
Fax: (613) 446-4556

### Pack List

Number: 61997

Date: 23-Oct-12

To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

Ship To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST  3 PCS D4410-041 1 PC D4410-043 4 PCS D4410-13 10 PCS D4410-11 12 PCS D4410-9  BLACK ANODIZE MIL-A-8625 TYPE 2 CLASS 2 Job: 20120643	Rev:	Line:
Certificate of Conformance  A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.  ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY  DATE: <u>23/10/12</u>  CERTIFIED SIGNATURE : _____  RECEIVER SIGNATURE : _____			